

Grey

Dart Aerospace Ltd.

Date: Wednesday, 18/02/2009 3:01:08 PM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : AFT FACING SEAT ASS'Y RH
Job Number : 45882	
Estimate Number : 13314	
P.O. Number :	Part Number : D412769044
This Issue : 18/02/2009 S.O. No. :	Drawing Number : D412-769-2 REVB
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 43046	Material :
Written By :	Due Date : 25/02/2009 Qty: 1 Um: Each
Checked & Approved By : <u>JD 09.02.18</u>	
Comment : Est rev A 08.05-12 new issue DD verified by:ec Est Rev:B 08-07-17 revB as per dwg DD verified by:ec Est Rev:C 08-08-21 move D3792-1 after powder coat DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Pick Packing Kit	
2.0	D3782045	Back Leg Assembly
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Back Leg Assembly batch: <u>B 42834</u>	
3.0	D3782041	Front Inboard Leg Assembly
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Front Inboard Leg Assembly batch: <u>42838</u>	
4.0	D3782044	Front Outboard Leg Assembly, RH
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Front Outboard Leg Assembly, RH batch: <u>B 49151</u>	
5.0	D3783041	Lateral Brace Assembly
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Lateral Brace Assembly batch: <u>B 49843</u>	

FF 09/02/23 ①

FF 09/02/23 ①

FF 09/02/23 ①

FF 09/02/23 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 18/02/2009 3:01:08 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASSY RH

Job Number: 45882

Part Number: D412769044

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D3783043	Longitudinal Brace Assembly
-----	----------	-----------------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Longitudinal Brace Assembly
batch: B42850x1 / ~~725421~~ 42586x1 FF 09/02/23 ①

7.0	D3783045	Angle Brace Assembly
-----	----------	----------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Angle Brace Assembly
batch: B42853 FF 09/02/23 ①

8.0	D3784041	Seat Support Assembly, Center
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Seat Support Assembly, Center
batch: B42857 FF 09/02/23 ①

9.0	D3784043	Seat Support Assembly, LH
-----	----------	---------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Seat Support Assembly, LH
batch: B42863 FF 09/02/23 ①

10.0	D3784044	Seat Support Assembly, RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Seat Support Assembly, RH
batch: B42869 FF 09/02/23 ①

11.0	D37662	Front Rail, RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Front Rail
batch: B42876 FF 09/02/23 ①

12.0	D37663	Rear Rail
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Rear Rail
batch: B42873 FF 09/02/23 ①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASSY RH

Job Number: 45882

Part Number: D412769044

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D37671

Upper Rail



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Upper Rail

batch: B42874

FF 09/02/23 ①

14.0

AN415A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M110399

FF 09/02/23 ①

15.0

AN45 13A

EYE BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

EYE BOLT

batch: M109712

FF 09/02/23 ①

16.0

AN510A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

batch: M110363

FF 09/02/23 ①

17.0

AN513A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M110363

FF 09/02/23 ①

18.0

AN960JD10

Washer



Comment: Qty.: 21.0000 Each(s)/Unit Total : 21.0000 Each(s)

Washer

batch: M110139

(or NAS1149D0363J) batch: _____

FF 09/02/23 ①

19.0

AN960JD416

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: M110523

(or NAS1149D0463J) batch: _____

FF 09/02/23 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASSY RH

Job Number: 45882

Part Number: D412769044

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN960JD516

Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Washer

batch: H110363

(or NAS1149D0568J) batch: _____

FF 09/02/23

21.0

AN52510R24

Screw



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Screw

batch: M109238

FF 09/02/23

22.0

MS21042L3

Nut



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Nut

batch: M109798

FF 09/02/23

23.0

MS21042L4

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: M109282

FF 09/02/23

24.0

MS21042L5

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

batch: M110382

FF 09/02/23

25.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble as per dwg D412-769-2

FF 09/02/23

26.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/23 @LPH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASSY RH

Job Number: 45882

Part Number: D412769044

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

POWDER COATING

POWDER COATING



M1109648



Comment: POWDER COATING

1- mask D3782-041 and D3782-043 front legs and D3787-1 foot as per dwg D412-769-041

2- install bolts in 3 place (in seat belt eye bolt holes) to ensure leg does not move when powder coating

3- Powder coat remaining of assembly grey as per dwg D412-769-2

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

10:30am

OVEN TEMPERATURE:

320°C

FINISH TIME:

11:00am

JJ

09/02/23

(X)

28.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FF 09/02/23 (1)

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

30.0

D37921

Seat Belt Eye Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Seat Belt Eye Bolt

B 40080

FF 09/02/24 (1)

31.0

D37751

Guard



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Guard

batch: 42875

FF 09/02/24 (1)

32.0

D37741

Seat Bottom, LH/RH



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Seat Bottom, LH

batch: B 40867

FF 09/02/24 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASSY RH

Job Number: 45882

Part Number: D412769044

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0

D37743

Seat Back, LH/RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Bottom, LH

batch: B41085

FF 09/02/24

34.0

AN525 10R22

Screw



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Screw

batch: M109267

FF 09/02/24

35.0

AN960JD10L

Washer



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Washer

batch: M109632

(or NAS1149D03325) batch: _____

FF 09/02/24

36.0

MS21042L3

Nut



Comment: Qty.: 19.0000 Each(s)/Unit Total : 19.0000 Each(s)

Nut

batch: M109798

FF 09/02/24

37.0

AN35A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

batch: M100188

FF 09/02/24

38.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- install remaining parts as per dwg D412-769-2

FF 09/02/24

39.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 09/02/24 (+12H)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 45882

Part Number: D412769044

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

PACKAGING 1

PACKAGING RESOURCE #1



Q

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PPP

46057

9/2/24

SD

41.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/25 JH

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-0274

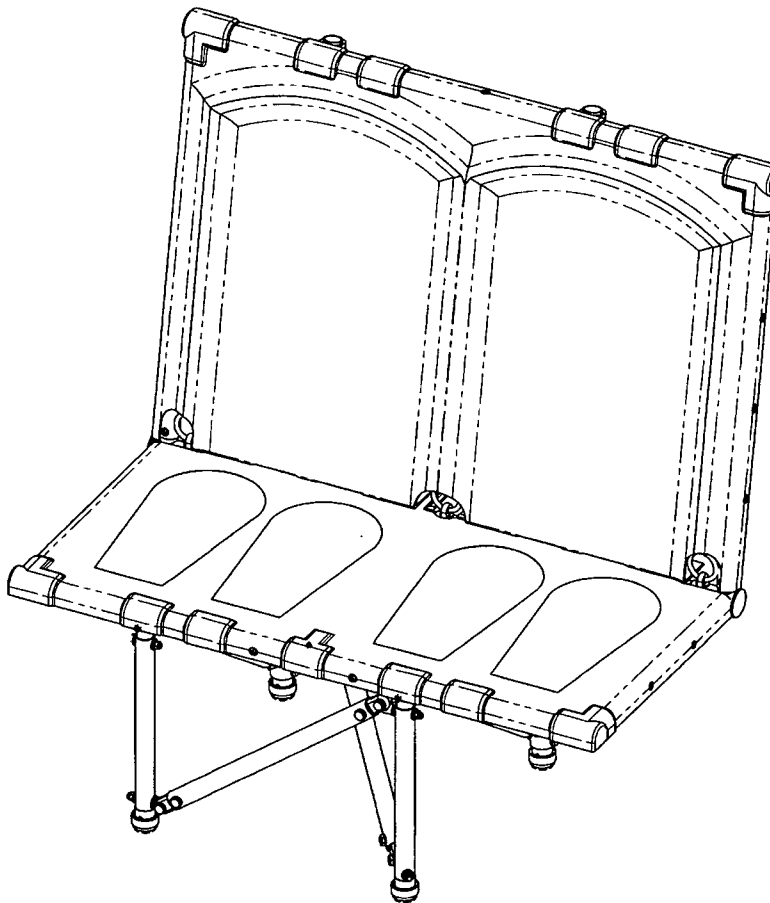
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



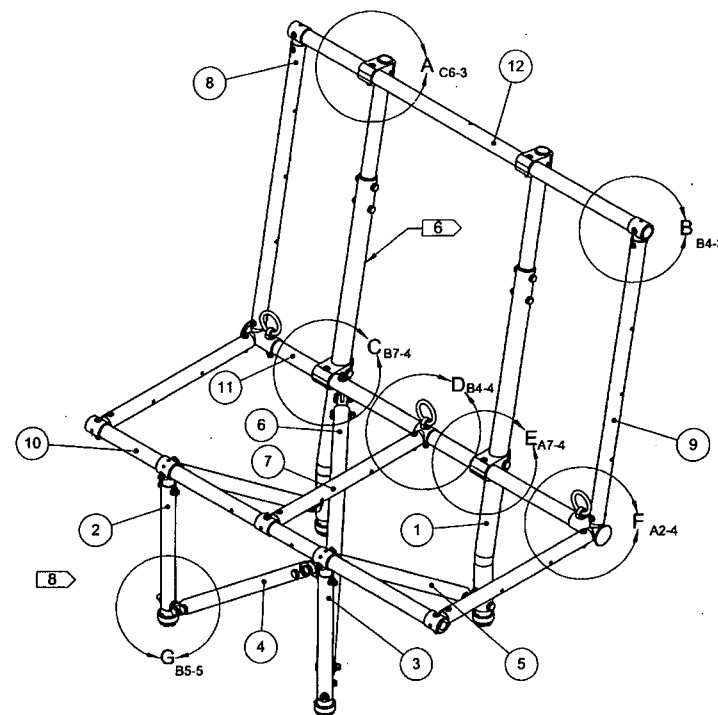
D412-769-044 AFT FACING SEAT, RH

RELEASE
08.07.10/10/04

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 45881

B	NEW HARDWARE	HS	08.06.25
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	HS	D412-769-2	SHEET 1 OF 7
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	AFT FACING SEAT ASSY, RH	NTS
DATE	08.06.25	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THE DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-044)
1	D3782-045	BACK LEG ASSY	2
2	D3782-041	FRONT INBOARD LEG ASSY	1
3	D3782-044	FRONT OUTBOARD LEG ASSY, RH	1
4	D3783-041	LATERAL BRACE ASSY	1
5	D3783-043	LONGITUDINAL BRACE ASSY	2
6	D3783-045	ANGLE BRACE ASSY	1
7	D3784-041	SEAT SUPPORT ASSY	1
8	D3784-043	SEAT SUPPORT ASSY, LH	1
9	D3784-044	SEAT SUPPORT ASSY, RH	1
10	D3766-2	FRONT RAIL, RH	1
11	D3766-3	REAR RAIL	1
12	D3767-1	UPPER RAIL	1
13	D3792-1	SEAT BELT EYE BOLT	3
14	D3775-1	GUARD	2
15	D3774-1	SEAT BOTTOM	1
16	D3774-3	SEAT BACK	1
17	AN3-5A	BOLT	6
18	AN4-15A	BOLT	2
19	AN45-13A	EYE BOLT	1
20	AN5-10A	BOLT	6
21	AN5-13A	BOLT	2
22	AN525-10R22	SCREW	13
23	AN525-10R24	SCREW	9
24	MS21042L3	NUT	28
25	MS21042L4	NUT	2
26	MS21042L5	NUT	12
27	NAS1149D0332J	WASHER (AN960JD10L)	13
28	NAS1149D0363J	WASHER (AN960JD10)	21
29	NAS1149D0463J	WASHER (AN960JD416)	4
30	NAS1149D0568J	WASHER (AN960JD516)	20



D412-769-044 AFT FACING SEAT, RH

RELEASED
08-07-10 11:10

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	HS	D412-769-2	SHEET 2 OF 7
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	AFT FACING SEAT ASSY, RH	NTS
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- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3 PRIOR TO INSTALLATION OF SEAT BOTTOM/BACK (D3774-1, -3). MASK FRONT LEGS PRIOR TO POWDER COAT
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH D2729-1 RED DECAL ATTACHED TO BACK LEG ASSEMBLY (D3782-045)
 - 7) WEIGHT: 30.0 lbs
 - 8) ITEM 15 (D3774-1 SEAT BOTTOM) AND ITEM 16 (D3774-3 SEAT BACK) REMOVED FOR CLARITY

NO. 45882
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WORK ORDER
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ENGINEERING

AN525-10R24 SCREW (1)
NAS1149D0363J WASHER (1)
MS21042L3 NUT (1)

D3767-1
UPPER RAIL
REF

D3782-045
BACK LEG ASSY
REF

DETAIL A D2-2
UPPER RAIL TO BACK LEG ATTACHMENT
2 PL

D3767-1
UPPER RAIL
REF

AN525-10R24 SCREW (1)
NAS1149D0363J WASHER (1)
MS21042L3 NUT (1)

D3784-044
SEAT SUPPORT ASSY, RH
REF

DETAIL B C1-2
SEAT SUPPORT END ATTACHMENT (TYP)
5 PL

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 45880

RELEASED
08-07-07

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	PH	D412-769-2	SHEET 3 OF 7
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	AFT FACING SEAT ASSY, RH	NTS
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D3782-045
BACK LEG ASSY
REF

AN45-13A EYE BOLT (1)
NAS1149D0568J WASHER (1)
MS21042L5 NUT (1)

D3786-3
REAR RAIL
REF

AN525-10R24 SCREW (1)
NAS1149D0363J WASHER (1)
MS21042L3 NUT (1)

DETAIL C C2-2
REAR RAIL TO BACK LEG ATTACHMENT

AN525-10R24 SCREW (1)
NAS1149D0363J WASHER (1)
MS21042L3 NUT (1)

D3784-041
SEAT SUPPORT ASSY, CENTER
REF

D3786-3
REAR RAIL
REF

DETAIL D C1-2
SEAT SUPPORT ASSY, CENTER ATTACHMENT

D3792-1 SEAT BELT EYE BOLT (1)
NAS1149D0568J WASHER (2)
MS21042L5 NUT (1)

D3792-1 SEAT BELT EYE BOLT (1)
NAS1149D0568J WASHER (2)
MS21042L5 NUT (1)

RELEASED
08.07.12/11/12

D3775-1
GUARD
REF




D3784-044
SEAT SUPPORT ASSY, RH
REF

DETAIL F B1-2
SEAT SUPPORT ATTACHMENT
2 PL

D3782-045
BACK LEG ASSY
REF

DETAIL E C2-2
REAR RAIL TO BACK LEG ATTACHMENT

SHOP COPY
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WORK ORDER
NO. 45882

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D412-769-2	SHEET 4 OF 7
APPROVED		TITLE	SCALE
DE APPR.		AFT FACING SEAT ASSY, RH	NTS
DATE	08.06.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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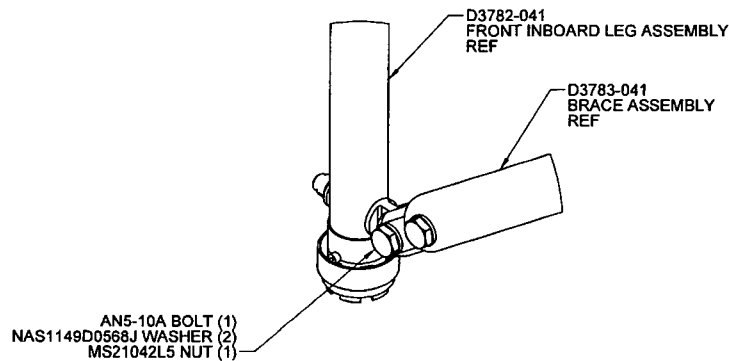
8 7 6 5 4 3 2 1

D

C

B

A



DETAIL G_{B3-2}
BRACE ATTACHMENT
6 PL

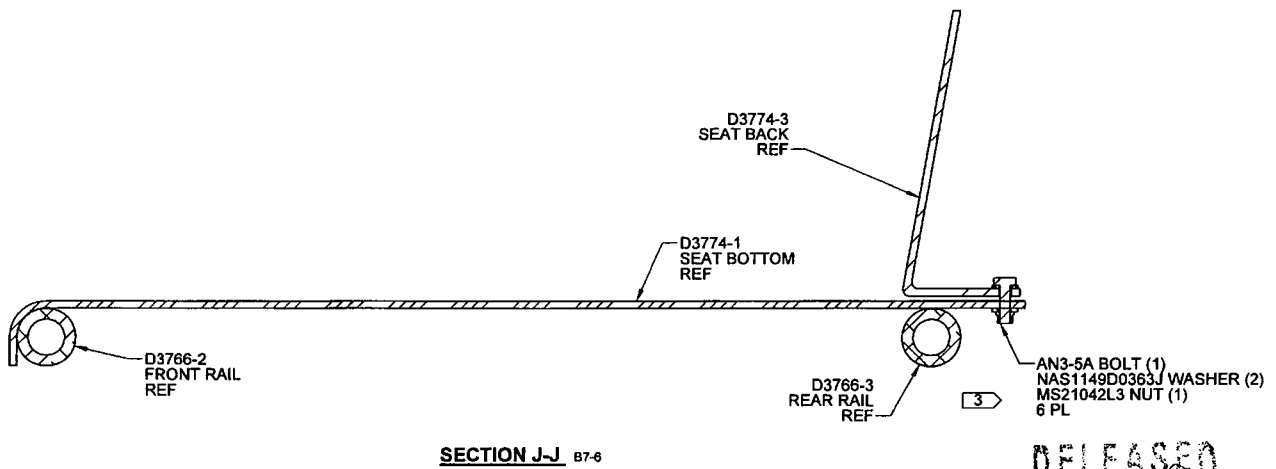
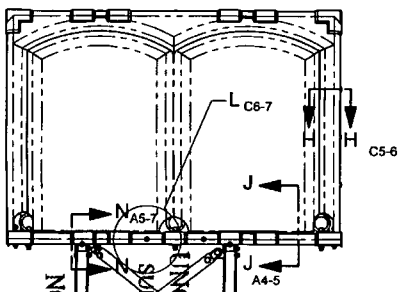
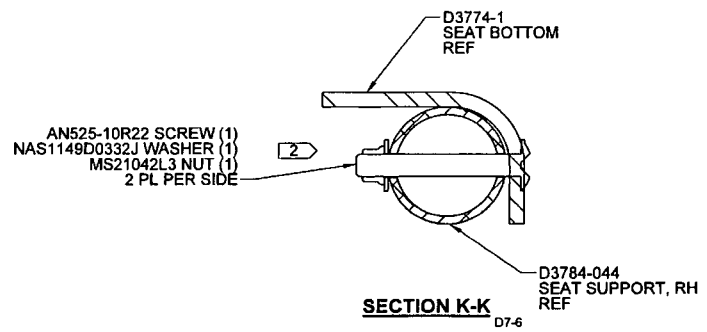
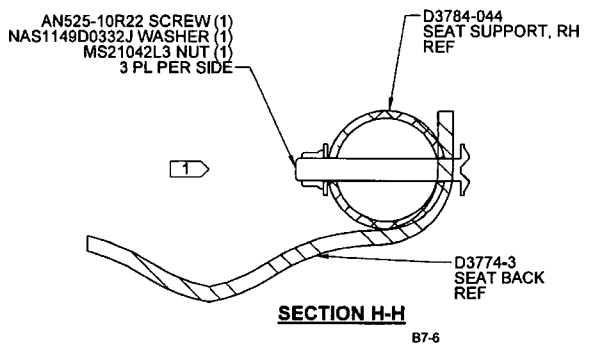
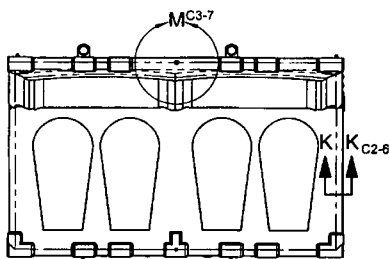
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DESIGN	HS	DART AEROSPACE LTD	
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CHECKED	<i>[Signature]</i>	DRAWING NO. D412-769-2	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 5 OF 7	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	AFT FACING SEAT ASSY, RH	NTS
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



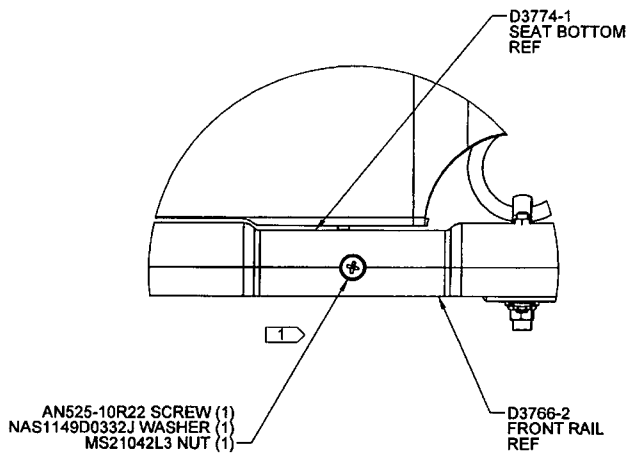
NO. 45802
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- NOTES:**
- 1) TRANSFER DRILL HOLES 001 FROM SEAT SUPPORTS (D3784-043/-044) TO SEAT BACK (D3774-3) - 3 PL/SIDE
 - 2) TRANSFER DRILL HOLES 001 FROM SEAT SUPPORTS (D3784-043/-044) TO SEAT BOTTOM (D3774-1) - 2 PL/SIDE
 - 3) TRANSFER DRILL HOLES 001 FROM SEAT BOTTOM (D3774-1) TO SEAT BACK (D3774-3) - 6 PL

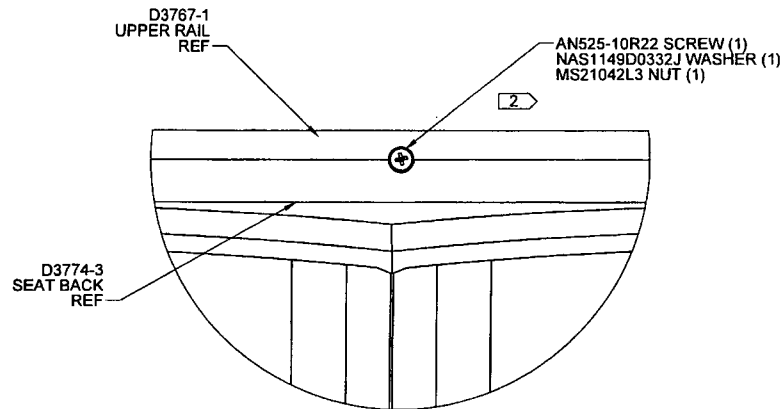
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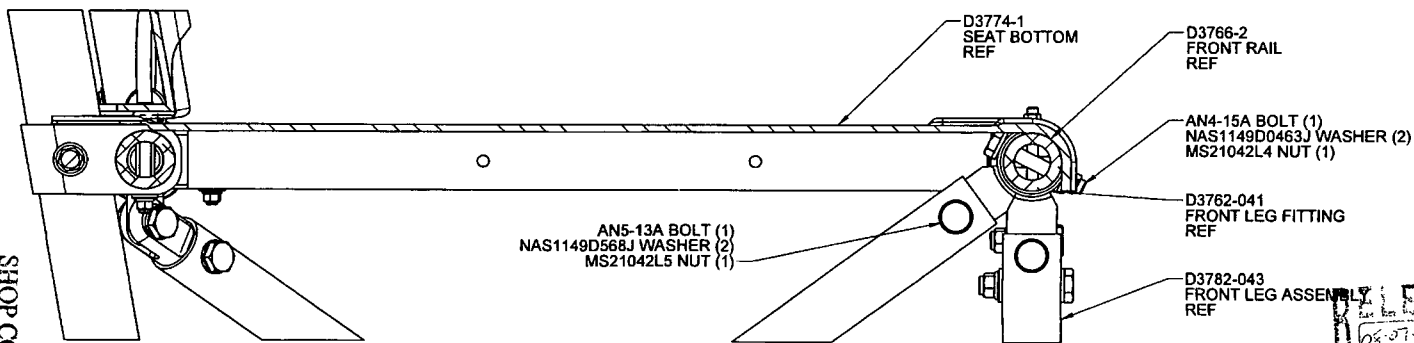
8 7 6 5 4 3 2 1



DETAIL L B7-6
SEAT BOTTOM ATTACH - FRONT DETAIL



DETAIL M D7-6
SEAT BACK ATTACH - TOP DETAIL



SECTION N-N B7-6
FRONT LEG AND LONGITUDINAL ANGLE ATTACHMENT

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- NOTES:
1) TRANSFER DRILL HOLES $\varnothing 0.201$ FROM FRONT RAIL (D3766-2) TO SEAT BOTTOM (D3774-1) - 2 PL
2) TRANSFER DRILL HOLES $\varnothing 0.201$ FROM UPPER RAIL (D3767-1) TO SEAT BACK (D3774-3) - 1 PL

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